



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3552-11
Job Sheet 174595



Part No: D3552-11

Job Qty: 12 ea

Part Name: Door Prop



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/19/18

Job Tracking No:

Due Date: 3/23/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV L IPP Rev:B 09-04-20 rev.d as per dwg DD verified by:EC IPP Rev:C as per dwg RevE DD 10.02.17
verified by:EC IPP Rev:D 10.12.03 as per dwg rev.G DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	12 pcs		3/23/18	0.00	0.00	Purchasing		ATD 3/23/18
110	Packaging	12 pcs		3/23/18	0.00	0.00	Packaging2		ATD 3/23/18
120	QC	12 pcs		3/23/18	0.00	0.00	QC6		9-89 MAR 28 2018
130	Packaging	12 pcs		3/23/18	0.00	0.00	Packaging3-1	57363 9-89	DAS 9-89 APR 03 2018
140	QC21-SA	12 Ea		3/23/18	0.00	0.00	QC21		13 MAR 19 2018

Part Op 100 - Issue P/O: 39356 Purchase Part Number: B8-240-575-150N Supplier: LS Technologies
Descriptions: 110 - Ensure certificate of conformity is attached
120 - Test for correct pressure

21 APR 03 2018
9-89 MAR 19 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
B8-240-575-150N	Gas Spring D3552-11	12 pcs (1 ea)	100-Purchasing	5055044

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	B8-240-575-150N	12	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

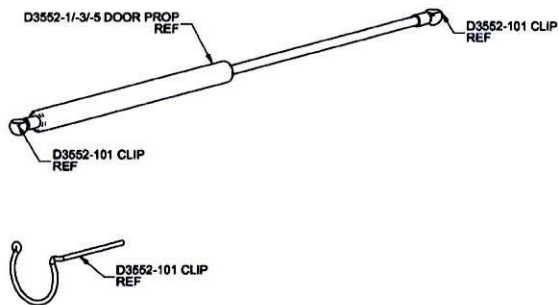
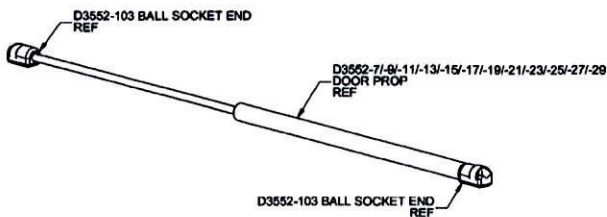


QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																					
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																					
Job No: 174595 Mfg Date: 03/26/18 Packaging Operation: Revision: Serial No/Batch: S055045 PART NO: D3552-11 Change No: Door Prop				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																					
Root Cause <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">No Re-verification ☐</td> <td style="width:15%;"></td> <td style="width:15%;"></td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td></td> <td></td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td></td> <td></td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td></td> <td></td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td></td> <td></td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td></td> <td></td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td style="width:15%;">Crushing ☐</td> <td style="width:15%;">Contamination ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Countersink ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Cut Too Short ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Instructions Incomplete/Unclear ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> <td>Drill Holes ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td colspan="2" style="text-align: center;">OTHER : _____</td> </tr> </table>				Environment ☐	No Re-verification ☐			Design ☐	Operator ☐			Doc/Data ☐	Offset/Setup ☐			Equip/Tooling ☐	Supplier ☐			Handling/Pre ☐	Training ☐			Material ☐	Use for Testing ☐			Internal Transport ☐	Poor Information ☐	Crushing ☐	Contamination ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Countersink ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Cut Too Short ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Instructions Incomplete/Unclear ☐	Past Expiry Date ☐	Manufacturing Process ☐		Drill Holes ☐	Misidentified ☐	Past Due ☐	OTHER : _____		<table style="width:100%; border: none;"> <tr><td>☐</td><td>Positioned Wrong</td></tr> <tr><td>☐</td><td>Outside Dimensions</td></tr> <tr><td>☐</td><td>Over/Under tolerance</td></tr> <tr><td>☐</td><td>Part Incorrect</td></tr> <tr><td>☐</td><td>Part Lost/Missing</td></tr> <tr><td>☐</td><td>Part Moved</td></tr> <tr><td>☐</td><td>Drawing</td></tr> <tr><td>☐</td><td>Finish</td></tr> <tr><td>☐</td><td>Misread</td></tr> <tr><td>☐</td><td>Turning Sequence</td></tr> </table>		☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence
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SPECIFICATION CONTROL DRAWING



RELEASED
2015-08-04
ECN 15-609

L	ADD PIN D3552-29	VS	15.04.13
K	ADD "X" TO LS TECHNOLOGIES PARTS TO DESIGNATE "EXTRA DAMPING" FOR D3552-15/-17/-19/-25/-27 REASON: PART 2-20	MB	12.07.18
J	ADD PIN D3552-25/-27. REMOVE ALTERNATE PART NUMBER FOR -15, -17 AND -19. STROKE FOR -15, -17 AND -19 WAS 1348.06 NOW 1548.06. EXTENDED LENGTH FOR -15, -17 AND -19 WAS 388/15.2 NOW 387/15.2	AP	11.12.07
I	ADD PIN D3552-23	RF	11.10.11
H	ADD PIN D3552-21	DC	11.03.10
G	FOR -15, FORCE 300N. 4 WAS 400/18.0. SUPPLIER PIN B8-154-387-200N WAS 68-154-387-400N. FOR -17, STROKE 1365.47 WAS 1806.30. EXT LG 388/15.2 WAS 427/18.0. SUPPLIER PIN B8-154-387-158N WAS B8-167-408-158N	JPH	10.11.01
F	ADD PIN D3552-15/-17/-19 AND ALTERNATE SUPPLIER	JPH	10.07.27
E	ADD PIN D3552-13 ZN B8-1. AS-1. D6-1. CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD PIN D3552-101 ZN D6-1. C7-1. C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1. ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN AS-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION. UPDATE PIN FOR D3552-7	LE	07.06.01
B	ADD D3552-7/-9. UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	VS		
DRAWN	VS		
CHECKED	AK		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS		
DATE	15.04.13		

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3552

TITLE

DOOR PROP

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REV. L

SHEET 1 OF 2

SCALE

NTS



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.8	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-140N
D3552-15	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300NX
D3552-17	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	150/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-150NX
D3552-19	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060NX
D3552-21	DOOR PROP	167/6.57	410/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-167-410-070N
D3552-23	DOOR PROP	190/7.48	475/18.7	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-190-475-070N
D3552-25	DOOR PROP W/EXTRA DAMPING	148/5.83	475/18.7	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-300NX
D3552-27	DOOR PROP W/EXTRA DAMPING	148/5.83	475/18.7	150/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-150NX
D3552-29	DOOR PROP	190/7.48	475/18.7	100/22.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-190-475-100N
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C8
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10

D3552-X DOOR PROP

RELEASED
2015-08-04

- NOTES:**
 1) IDENTIFICATION: IDENTIFY PER QSI 044 6.2
 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-11/31-5 DOOR PROPS
 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/9/11/13/15/17/19/21/23/25/27/29 DOOR PROPS

APPROVED	DESIGN	VS	DART AEROSPACE LTD	
	DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AK	DRAWING NO.	REV. L
	MFG. APPR.	DO	D3552	SHEET 2 OF 2
	APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DOOR PROP		NTS
DATE	15.04.13			

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 2015-08-04



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039356

Supplier: LST001-VC
LS Technologies Inc.
1634 Saskatchewan Ave.
Saskatoon
SK
S7K 1P6 Canada
Phone: 306 683 5000
Fax: 306 683 6403

PO No: PO039356

PO Date: 3/19/18

Due Date: 3/26/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
MAR 19 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	B8-240-575-150N			Gas Spring D3552-11 As Per Dwg D3552 Rev. L	Firmed	3/26/18	12 pcs	0 pcs	12 pcs	\$33.00/pcs	\$396.00
Line Item Note job # #174595 Grand Total: \$396.00											

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 3/19/18 2:42 PM dart.lavoie.chantal

DAS
11
9-89



LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

March 20, 2018

This is to certify that the parts listed below meets specifications as required by your order.

12 Units: D3552-11 #174595 Gas Spring

Country of Manufacture: Canada
Date of Manufacture : March 2018
This product is ROHS compliant.

Purchase Order # 039356
Invoice # 18123

L S Technologies Inc Canada

A blue ink signature of Nolan Fehr, written in a cursive style, positioned above a horizontal line.

Nolan Fehr
President